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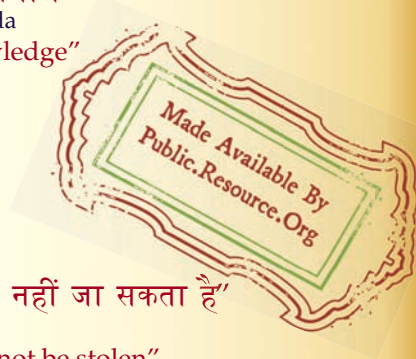
IS 13560 (1992): Textile machinery and accessories - Drum pulleys used in ring spinning and doubling frames [TXD 14: Machinery for Fabric Manufacture]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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भारतीय मानक

वस्त्रादि मशीनरी एवं सहायकांग — रिंग कताई और
डबलिंग फ्रेमो में प्रयुक्त ड्रम गिरियां — विशिष्टि

Indian Standard

TEXTILE MACHINERY AND ACCESSORIES —
DRUM PULLEYS USED IN RING SPINNING
AND DOUBING FRAMES — SPECIFICATION

UDC 677·052·31 : 677·052·63 : 621·85·051

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

September 1992

Price Group 1

FOREWORD

This Indian Standard was adopted by the Bureau of Indian Standards, after the draft finalized by the Spinning Preparatory, Spinning and Doubling (Twisting) Machinery Sectional Committee had been approved by the Textile Division Council.

Drum pulley is used to drive the roller bearing spindles on ring frames and ring doublers by means of spindle driving tapes. The drive is generally four spindle drive.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

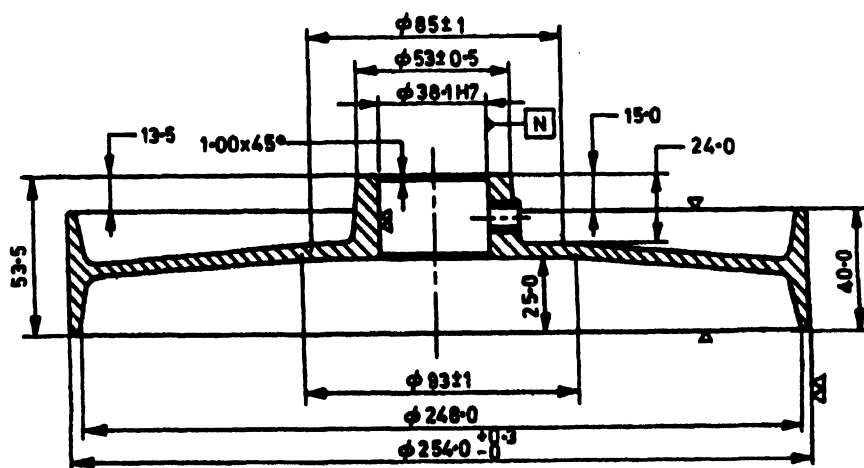
**AMENDMENT NO. 1 JUNE 2003
TO
IS 13560 : 1992 TEXTILE MACHINERY AND
ACCESSORIES — DRUM PULLEYS USED IN RING
SPINNING AND DOUBLING FRAMES —
SPECIFICATION**

Substitute 'DRUM PULLEYS/TR PULLEYS' for 'DRUM PULLEYS' on the cover page and wherever it occur in the text of the standard.

(Page 1, clause 4.1) — Substitute the following for the existing clause:

'4.1 The dimensions of the drum pulleys/TR pulleys shall be as agreed to between the buyer and the seller. The dimensions of a typical drum pulley and that of TR pulley are shown in Fig. 1 and Fig. 2 respectively. The bore of the pulley shall conform to the tolerances as specified by the ring frame manufacturer.'

(Page 1, clause 4.1) — Insert Fig. 2 below Fig. 1:



All dimension in millimetres.

FIG. 2 TR PULLEY

(TX 15)

Indian Standard

TEXTILE MACHINERY AND ACCESSORIES — DRUM PULLEYS USED IN RING SPINNING AND DOUBLING FRAMES — SPECIFICATION

1 SCOPE

This standard prescribes the requirements of drum pulleys used on ring frames and ring doublers to drive spindles.

2 REFERENCE

IS 10719 : 1983 'Method of indicating surface textures on technical drawing' is a necessary adjunct to this standard.

3 MANUFACTURE

3.1 Material

The drum pulley shall be manufactured from sheet steel, die cast light alloy or moulded polymeric materials as agreed to between the buyer and seller.

3.2 Shape and Surface

The outer surface of the pulley shall be free from scratches, indentations, burrs and such other defects which cause damage to the spindle tapes. The pulleys shall have well rounded smooth surface without sharp edges

or corners to avoid accumulation of fluff, from the shape or from electrostatic properties during operation.

3.3 The drum pulleys shall be of solid type or of split flange type. If latter, they shall have Dowell pins or Tennon Keyforms in the hub and the periphery to eliminate any discontinuity at drive surface. All split pulleys shall have firm grip on the shafts. Even on repeated assembly/disassembly, the run out and out-of-balance tolerances as achieved during manufacture shall be retained.

3.4 The drum pulleys shall have the material well distributed to have the unbalance before machining within 150 gcm. In service conditions, the drum pulley shall satisfy the requirements given in 3.

4 REQUIREMENTS

4.1 The dimensions of the drum pulley shall be as agreed to between the buyer and the seller. The dimensions of a typical drum pulley are shown in Fig. 1. The bore of the pulley shall conform to the tolerances as specified by the ring frame manufacturer.

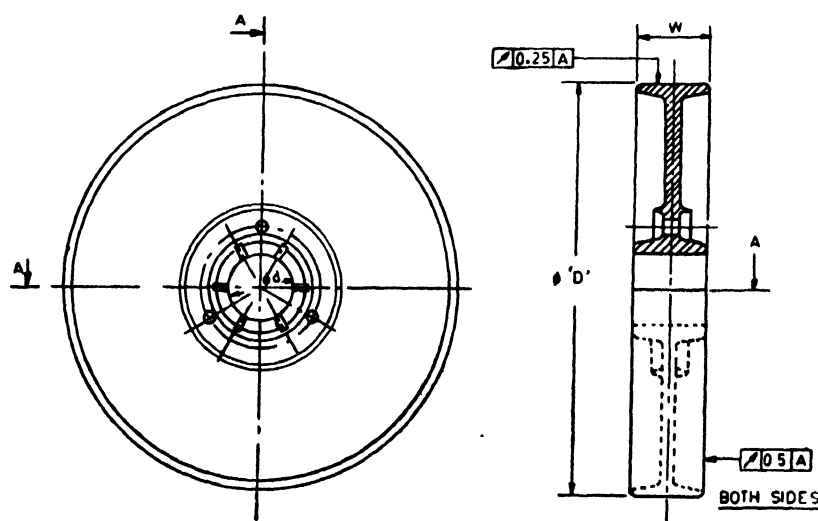


FIG. 1 TYPICAL DRUM PULLEY

IS 13560 : 1992

4.2 The run-out of the pulley on assembly shall not exceed the values as given below:

Bore surface to outside diameter	—	0.2 mm TIR
Bore surface to face	—	0.3 mm TIR

4.3 Surface Finish

The permissible surface finish of the drum pulley shall be N 7 (*see* IS 10719 : 1983) on machined working surface areas and N 9 on machined non-working surface areas and all other surfaces.

4.4 Balancing

The drum pulley shall be dynamically balanced to have the residual out-of-balance within 25 gcm at a speed agreed to between the buyer

and the seller.

5 MARKING

5.1 Each drum pulley shall be marked with the indication of the source of manufacture.

5.2 The drum pulley may also be marked with the Standard Mark.

6 PACKING

Each pulley shall be wrapped in kraft paper or polyethylene film. A convenient number of wrapped pulleys shall be packed in a wooden case. In case the drum pulleys are assembled on the drum pulley shaft, each drum pulley shaft assembly shall be packed in a convenient number in a wooden box in such a manner that during transit, the assemblies are not damaged.

Standard Mark

The use of the Standard Mark is governed by the provisions of the *Bureau of Indian Standards Act, 1986* and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers may be obtained from the Bureau of Indian Standards.

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BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones : 331 01 31, 331 13 75

Telegrams : Manaksanstha
(Common to all Offices)

Regional Offices :

Central : Manak Bhavan, 9 Bahadur Shah Zafar Marg
NEW DELHI 110002

Telephone

{ 331 01 31
{ 331 13 75

Eastern : 1/14 C. I. T. Scheme VII M, V. I. P. Road, Maniktola
CALCUTTA 700054

{ 37 84 99, 37 85 61,
{ 37 86 26, 37 86 62

Northern : SCO 445-446, Sector 35-C, CHANDIGARH 160036

{ 53 38 43, 53 16 40,
{ 53 23 84

Southern : C. I. T. Campus, IV Cross Road, MADRAS 600113

{ 235 02 16, 235 04 42,
{ 235 15 19, 235 23 15

Western : Manakalaya, E9 MIDC, Marol, Andheri (East)
BOMBAY 400093

{ 632 92 95, 632 78 58,
{ 632 78 91, 632 78 92

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